

Work Order ID 126633

126633

Page 1

Wednesday, November 19, 2014 8:47:53 AM

Item ID: D350-636-113 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Glacier Landing Wearplates Deluxe (Run-on Landing Skidtubes Compatible)
 Start Date: 11/19/2014 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/19/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-11-19 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9662	B

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo <i>M. 10</i>	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-636-113 CHG001								

2x DAS 28 9-89 MAY 13 2015

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

2x DAS 28 9-89 MAY 13 2015

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

② 1505-15 DAS 28 9-89 MAY 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Required Date: 11/19/2014 Req'd Qty: 2.00 ***2*** Customer:
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-636-113								
	Location: <u>SMK</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

2 NS 15/05/15

HS-5-15 M-LJ

MAY 19 2015

HS-5-15

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, November 19, 2014 8:48:57 AM

Page 1

Work Order ID: 126633

126633

Parent Item: D350-636-113

D350-636-113

Parent Item Name: Glacier Landing Wearplates Deluxe (Run-on Landing Skid tubes Compatible)

Start Date: 11/19/2014

Required Date: 11/19/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.11.13 DSI REVB DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4934-041		Manufactured	No				Each	8.0000					
-----------	--	--------------	----	--	--	--	------	--------	--	--	--	--	--

D4934-041

Blade Assembly

**

DAS
28
9-89

MAY 13 2015

Location	Loc Qty	Loc Code
ST537	8	
116172	2	
117798	6	

128807 2X

126629 2X

D5146-041		Manufactured	No				Each	0.0000					
-----------	--	--------------	----	--	--	--	------	--------	--	--	--	--	--

D5146-041

Wearplate Assembly

prelim

B: 132897

**

DAS
28
9-89

DAS
26
9-89

AN3C36A		Purchased	No				Each	164.0000					
---------	--	-----------	----	--	--	--	------	----------	--	--	--	--	--

AN3C36A

Bolt

**

DAS
28
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	25	
101261	4	
122204	11	
124827	10	
ST338a	50	
m130874	50	
ST347	89	
m127769	1	
m128398	9	
m129907	79	

132169

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, November 19, 2014 8:48:57 AM

Page 2

Work Order ID: 126633

126633

Parent Item: D350-636-113

D350-636-113

Parent Item Name: Glacier Landing Wearplates Deluxe (Run-on Landing Skidtubes Compatible)

Start Date: 11/19/2014

Required Date: 11/19/2014

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

Each

770.0000

16

DAS
28
9-89

MAY 13 2015

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG	80	
103691	80	
GA	12	
m130186	12	
ST304	678	
m128398	16	
m129472	9	
m129521	17	
m130673	636	

131340

DAS
26
9-89

NAS1149C0332R

Purchased

No

Each

6,685.000

32

DAS
28
9-89

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

CA	83	
m129682	83	
ST278	6602	
122063	41	
125654	237	
m126319	51	
m127306	1425	
m127831	26	
m128591	75	
m129499	191	
m130325	3556	
m130466	1000	

131618

DAS
26
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. J
AND INSTRUCTIONS FOR CONTINUING AIRWORTHINESS ICA-D350-636 REV. 3
REF. FAA STC: SR00646SE
REF. CANADIAN STC: SH99-7
REF. EASA STC: 10033942

1.0 PURPOSE

The purpose of this service instruction is to introduce the D350-636-111/-113 Wearplate Kits.

The D350-636-111 Wearplate Kit replaces elements of the D350-636-011/-012/-013/-014 Skidtubes and elements of the D350-636-041/-043/-045 Wearshoe Kit and is designed to improve grip on low friction surfaces such as ice. The components in the D350-636-111 Wearplate Kit are defined in the parts list in Section 2.0.

The D350-636-113 Wearplate Kit replaces elements of the D350-636-015/-016/-017/-018 Skidtubes and elements of the D350-636-047 Wearplate Kit and is designed to improve grip on low friction surfaces such as ice. The components of the D350-636-113 Wearplate Kit are defined in the parts list in Section 2.0

2.0 PARTS LIST

QTY -111	QTY -113	Part Number	Description
X		D350-636-111	WEARPLATE KIT
	X	D350-636-113	WEARPLATE KIT
4		D4923-041	WEARPLATE ASSY
2		D4933-041	WEARPLATE ASSY
2	2	D4934-041	BLADE ASSY
	2	D5146-041	WEARPLATE ASSY
24		AN3C5A	BOLT
	8	AN3C36A	BOLT
	8	MS21043-3	NUT
24	16	NAS1149C0332R	WASHER (AN960C10)

14-11-19
ML5
NO 126633
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

B	ADD D350-636-113 WEARPLATE KIT	DB	14.08.21
A	NEW ISSUE	DB	13.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	<i>MKA</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	WEARPLATE INSTALLATION SHEET 1 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DSI 9662	NTS
DATE	14.08.21	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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3.0 WEIGHT AND BALANCE

The following are the net weight increases associated with the D350-636-111 and D350-636-113 Kits.

Installation	Weight	LONGITUDINAL		LATERAL (STD GEAR)		LATERAL (HIGH GEAR)	
		Arm	Moment	Arm	Moment	Arm	Moment
*D350-636-111 WEARPLATE KIT	3.82 lb 1.74 kg	132.1 in 3.4 m	504.6 in-lb 5.9 m-kg	0	0	0	0
**D350-636-113 WEARPLATE KIT	1.8 lb 3.96 kg	123.2 in 3.15 m	221.8 in-lb 12.5 m-kg	0	0	0	0

* Weight added to relevant skidtube installation when D350-636-111 Wearplate Kit is installed as replacement on D350-636-011/-012/-013/-014 Skidtubes.

**Weight added to relevant skidtube installation when D350-636-113 Wearplate Kit is installed as replacement on D350-636-015/-016/-017/-018 Skidtubes.

4.0 INSTALLATION OF D350-636-111 WEARPLATE KIT

- 4.1 Refer to Figure 1 on sheet 3 of this Service Instruction. Remove and retain the components indicated per ICA-D350-636, Sections 32.3 and 32.4. Ensure the AN8 fasteners are serviceable.
- 4.2 Inspect skidtube per ICA-D350-636.
- 4.3 Refer to Figure 2 on sheet 3 of this service instruction. Install the D4934-041 Blade Assy. Torque the AN8C21A bolts to 480-690 in-lbs (54.2-78.0 N-m).
- 4.4 Refer to Figure 2 on sheet 3. Install the D4923-041 Wearplate Assy and the D4933-041 Wearplate Assy as shown. Torque the AN3C5A bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 4.5 Repeat this procedure for the other Skidtube.
- 4.6 Adjust Weight and Balance per Section 3.0 of this Service Instruction.

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	<i>M Lee</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	WEARPLATE INSTALLATION SHEET 2 OF 4	
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DSI 9662	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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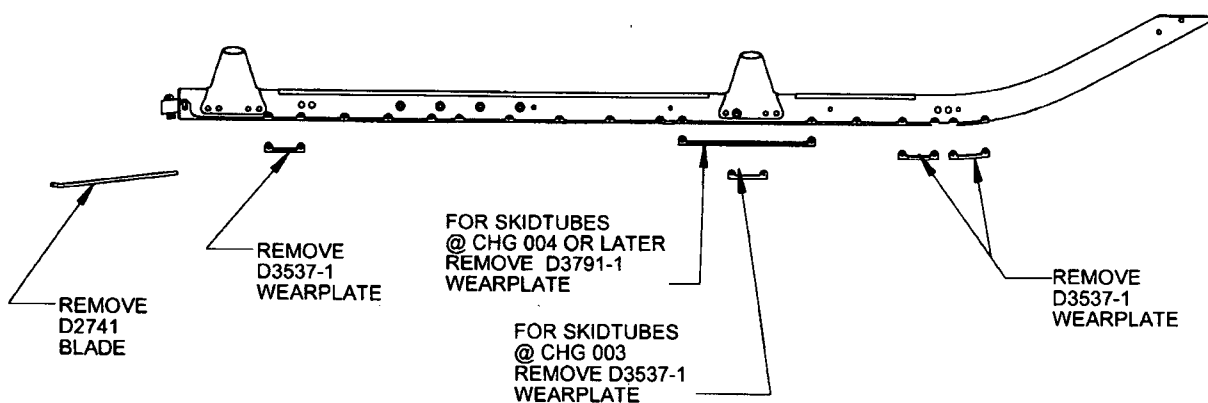


FIGURE 1: BLADE/WEARPLATE REMOVAL

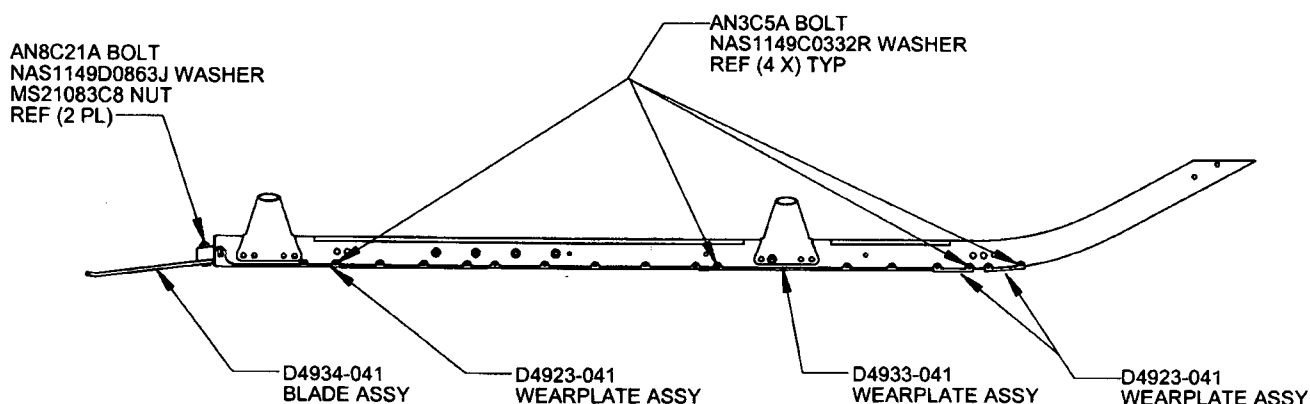


FIGURE 2: D350-636-111 WEARPLATE INSTALLATION

NOTE: THE 2 x D4923-041 WEARPLATES CAN BE INSTALLED IN ANY 2 OF THE 3 LOCATIONS INDICATED IN FIGURE 2 ABOVE. A PARTIAL INSTALL OF THE COMPONENTS PROVIDED IN THE D350-636-111 KIT IS ACCEPTABLE AS LONG AS THE INSTALLATION IS THE SAME ON BOTH SKIDTUBES.

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	<i>McLee</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	WEARPLATE INSTALLATION SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DSI 9662	NTS
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other	Other
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

5.0 INSTALLATION OF D350-636-113 WEARPLATE KIT

- 5.1 Refer to Figure 3 below. Remove and retain the components indicated per ICA-D350-636, Sections 32.3 and 32.4. Ensure the AN8 fasteners are serviceable.
- 5.2 Inspect skidtube per ICA-D350-636.
- 5.3 Refer to Figure 4 below. Install the D4934-041 Blade Assy. Torque the AN8C21A bolts to 480-690 in-lbs (54.2-78.0 N-m).
- 5.4 Refer to Figure 4 below. Install the D5146-041 Wearplate Assy as shown. Torque the AN3C36A bolts to 15-25 in-lbs (1.7-2.8 N-m). Torque the AN8C35A bolt to 480-690 in-lbs (54.2-78.0 N-m).
- 5.5 Repeat this procedure for the other skidtube.
- 5.6 Adjust Weight and Balance per Section 3.0.

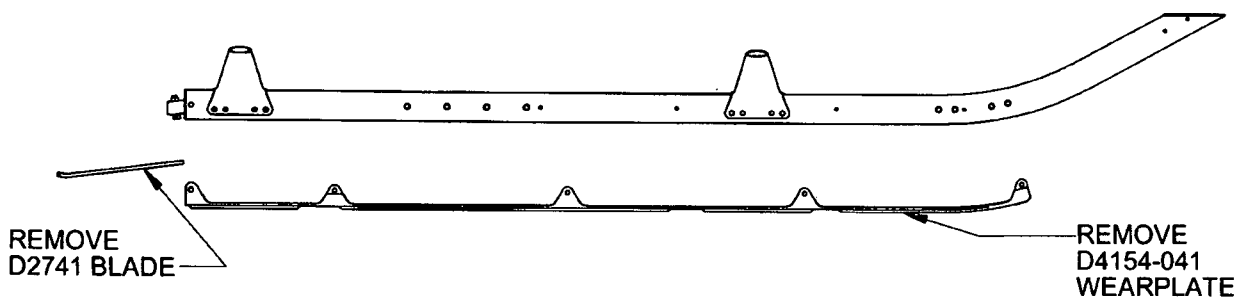


FIGURE 3: BLADE/WEARPLATE REMOVAL
(RETAIN FASTENERS)

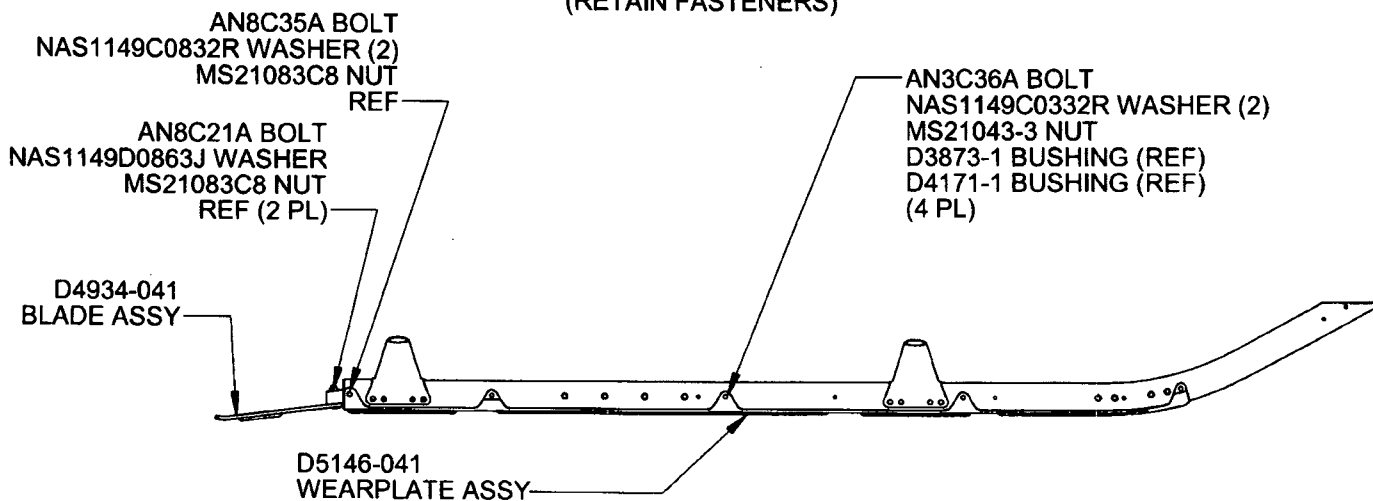


FIGURE 4: D350-636-113 WEARPLATE INSTALLATION

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	<i>mke</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	WEARPLATE INSTALLATION SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DSI 9662	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. J
AND INSTRUCTIONS FOR CONTINUING AIRWORTHINESS ICA-D350-636 REV. 3
REF. FAA STC: SR00646SE
REF. CANADIAN STC: SH99-7
REF. EASA STC: 10033942

1.0 PURPOSE

The purpose of this service instruction is to introduce the D350-636-111/-113 Wearplate Kits.

The D350-636-111 Wearplate Kit replaces elements of the D350-636-011/-012/-013/-014 Skidtubes and elements of the D350-636-041/-043/-045 Wearshoe Kit and is designed to improve grip on low friction surfaces such as ice. The components in the D350-636-111 Wearplate Kit are defined in the parts list in Section 2.0.

The D350-636-113 Wearplate Kit replaces elements of the D350-636-015/-016/-017/-018 Skidtubes and elements of the D350-636-047 Wearplate Kit and is designed to improve grip on low friction surfaces such as ice. The components of the D350-636-113 Wearplate Kit are defined in the parts list in Section 2.0

2.0 PARTS LIST

DAS
9
9-89 1505-15

QTY -111	QTY -113	Part Number	Description
X		D350-636-111	WEARPLATE KIT
	X	D350-636-113	WEARPLATE KIT
4		D4923-041	WEARPLATE ASSY
2		D4933-041	WEARPLATE ASSY
2	2	D4934-041	BLADE ASSY
	2	D5146-041	WEARPLATE ASSY
24		AN3C5A	BOLT
	8	AN3C36A	BOLT
	8	MS21043-3	NUT
24	16	NAS1149C0332R	WASHER (AN960C10)

B	ADD D350-636-113 WEARPLATE KIT	DB	14.08.21
A	NEW ISSUE	DB	13.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	<i>MKa</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	WEARPLATE INSTALLATION SHEET 1 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DSI-9662	NTS
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